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D4961-043
Job Sheet 202258



Part No: D4961-043

Job Qty: 8 pcs

Part Name: Tube Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/23/19

Job Tracking No:

Due Date: 11/6/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP REV:A 15.02.18 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	8 pcs	11/6/19		0.00	4.99	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
120	QC 5	8 pcs	11/6/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	8 pcs ✓	11/6/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B ✓		
							Packaging 3 - 4 - B4B		

GP 19-10-25

OCT 25 2019

Oscar OCT 25 2019

ST/29

				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	8 pcs ✓	11/6/19	0.00 0.00	QC 21 - SA - 21 ✓	ST 129
				QC 21 - SA - 70	DAS
				QC 21 - SA - 53	21

OCT 28 2019

Part Op 110 - (Small Fab) 1- Cut D4961-3 tube to size as per dwg 2- On one side of tube flare end as per dwg then slide sleeves
 Descriptions: and nuts, flare other side of tube as per dwg.

120 - (QC5- Inspect part completeness to step on W/O) QC5- Inspect part completeness to step on W/O

130 - (Identify as per dwg & Stock Location: _____) Identify as per dwg & Stock Location: _____

140 - (QC21- Final Inspection - Work Order Release) QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN818-L12J	Nut OVER007	16 Ea (2 ea)	110-Small Fab - 1	225282
M304TR0.750W.049	304 Round Tube .750 X .049W 2	2 ft (.25 ea)	110-Small Fab - 1	205919
MS20819-12J	Sleeve OVER006	16 Ea (2 ea)	110-Small Fab - 1	203407

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	AN818-L12J	16	30	0
	M304TR0.750W.049	2	97	0
	MS20819-12J	16	29	0

Part Specifications

Specifications could not be found.



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Cross tube ☐
Small Fab ☐
Finishing ☐
Skid-tube ☐
Machining ☐
Large Fab ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐
Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

MRB (QS1042)

QTY Affected: _____

Sequence #: _____

Date: _____

Disposition

Description Work Order Deviation

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

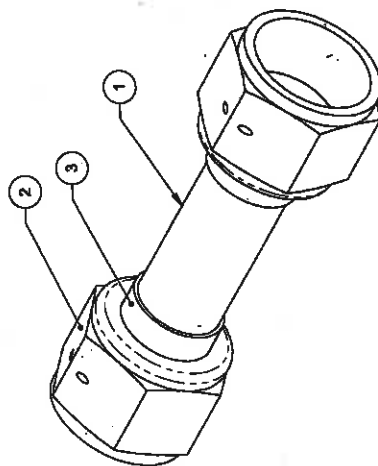
Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
☐	☐	☐	☐
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
☐	☐	☐	☐
Crushing	BOM/Route	Grain Direction	Drawing
☐	☐	☐	☐
Cracks	Broken/Damage/Defect	Weld	Finish
☐	☐	☐	☐
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
☐	☐	☐	☐
Marks/Chatter	Drill Holes	Out of Sequence	Misread
☐	☐	☐	☐
Mislabeled	Fit/Function	Off-set/Set-up	
☐	☐	☐	

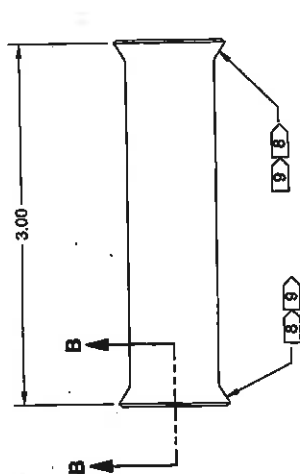
Other/Details: _____

ITEM	QTY	P/N	DESCRIPTION
	443		
	X	D4961-043	TUBE ASSEMBLY
1	1	D4961-3	TUBE
2	2	AN818-112J	NUT, TUBE COUPLING (DRILLED)
3	2	MS20819-12J	SLEEVE

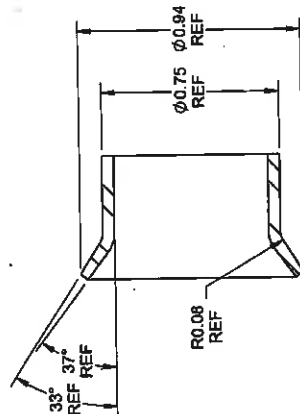


D4961-043 TUBE ASSEMBLY

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING, $\phi 0.750 \times 0.049$ WALL PER ASTM A213 OR ASME SA213 OR ASTM A269 (REF DART SPEC M304TR)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.44 lbs
 - 8) FLARE TUBE PER MS33584
 - 9) CLEAN INSIDE OF TUBE AFTER FLARING ENDS



D4961-3 TUBE



SECTION B-B

RELEASED
R 2016-08-04

DESIGN	VS	DART AEROSPACE LTD
DRAWN	CC	HAWKESBURY, ONTARIO, CANADA
CHECKED	VS	DRAWING NO.
MFG. APPR.	DD	D4961
APPROVED	HS	TITLE
DE APPR.	DS	TUBE ASSEMBLY
DATE	16.06.21	NTS
		SHEET 2 OF 3
		SCALE
		REV. C

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